

ABSTRACT

5       The present invention, in a method of casting an  
austenitic stainless steel thin strip casting with a  
continuous caster wherein mold walls move synchronously  
with the casting: provides a production method for  
preventing pepper-and-salt unevenly glossy defects  
distributed zigzag in the form of spots from appearing on  
a steel sheet after cold rolling and cold forming; and is  
10       a method for producing an austenitic stainless steel thin  
strip casting, characterized by regulating a pressing  
force  $P$  of mold wall faces against the casting in the  
range from more than 1.0 to less than 2.5 t/m, preferably  
from more than 1.1 to not more than 1.6 t/m. In the  
15       production method: the continuous caster used is a twin-  
drum type continuous caster; the drum radius  $R$  (m) and  
the pressing force  $P$  (t/m) of mold wall faces satisfy the  
relation  $0.5 \leq (\sqrt{R}) \times P \leq 2.0$ , preferably  $0.8 \leq (\sqrt{R}) \times$   
 $P \leq 1.2$ ; the height of a molten steel pool formed  
20       between mold walls is not less than 200 to not more than  
450 mm; and in-line rolling is applied during the process  
from molding to coiling.

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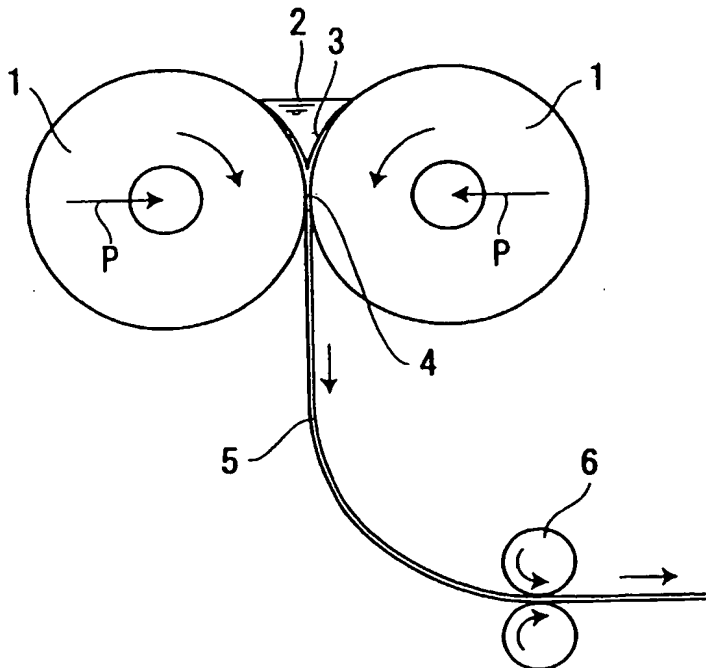
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(54) Title: METHOD OF MANUFACTURING AUSTENITIC STAINLESS STEEL SHEET CAST PIECE

(54) 発明の名称: オーステナイト系ステンレス鋼薄帯状鋳片の製造方法



(57) Abstract: A method of manufacturing, by casting, an austenitic stainless steel sheet cast piece by continuous casting equipment having mold walls moving in synchronism with the cast piece capable of preventing punctate and staggered marbling uneven brightness found on a steel sheet after cold drawing and cold working, characterized in that a pressing force (P) of the surface of the mold walls against the cast piece is more than 1.0 to less than 2.5 t/m, desirably more than 1.1 to 1.6 t/m or less. The continuous casting equipment of a double drum type, wherein a relation between a drum radius R (m) and the pressing force P (t/m) of the surfaces of the mold walls is  $0.5 \leq (\sqrt{R}) \cdot P \leq 2.0$ , desirably  $0.8 \leq (\sqrt{R}) \cdot P \leq 1.2$ , the height of a molten steel pool formed between the mold walls is 200 to 450 mm, and an in-line rolling is applied to the cast piece between the mold process and a winding process.

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WO 03/080273 A1